

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029749**Date Inspected:** 18-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Piping and pipe supports**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various fillet welds of the East and West Orthotropic Box Girders (OBG's).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

The welding continued this day of the reinforced W-Tee assembly for pipe support #PS-7 to the Westbound Barrier Rail at location W5/PP126(-350) as per detail 25D11A and per detail 8/D6a. The welding was performed by F.W.Spencer welder Barry Mullaney #6520 utilizing E7018 electrodes as per WPS# FWS Fillets Murex SFOBB Rv1. AB/F Quality Control (QC) Inspector William Sherwood was present and monitoring the WPS parameters of the welding in progress. All these welds appeared to meet the requirements of the contract documents.

This QAI witnessed the fillet-welding of the axial mounted piping key-plate tab weld #061813-01 to the 2-1/2" diameter water line at the Bikepath location PP28(-1600). The welding was performed by Tim Esquivel #8348 of F.W.Spencer utilizing E7018 electrodes as per the approved WPS #FWS Fillets Murex SFOBB Rev.1. The AB/F QC inspector Fred Michels was present, monitoring the WPS parameters of the welding in progress. These welds appeared to meet the requirements of the contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were general conversations with the contractor's Quality Control personnel at the start of the shift regarding the location of welding and inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris, Monty
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Quality Assurance Inspector

Reviewed By:	Reyes, Danny
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QA Reviewer
